

CARGO BASKET BODY FABRICATION - COMMON

2014-73

AS 350 long x l

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

Options 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

→ 78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket

Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right

90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

Options 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

MD600

82811, Revision 0 – Standard Basket

Options – Applicable to all models

70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2014-73

Date Open: 19 Sep 14

1. Rim Assembly – Basket Body

AB

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

2. Weld Rim Assembly.

AD-05

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

3. Inspection

AD-06

- a. Rim for complete welds

4. Frame assembly – body

AD-06

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
 - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - i. Ensure correct order and orientation of hoops. Refer to drawing.
 1. Attachment lugs are on inboard side.
 2. Handle bracket bushings are on outboard side, second hoop from both ends.
May be on attachment hoops.
 - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

AD-05

6. Inspection

- a. Frame assembly for complete welds.

A004

7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 - 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

4206

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require $\frac{1}{2}$ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/4" down at 60 degrees.
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

AD-05

8. Weld mesh to frame assembly per drawing.
 - a. Ensure lug locating jig is in place prior to welding.
 - b. General welding requirements for all baskets, MIG welding:
 - i. Every intersection at top edges.
 - ii. Every intersection at ends.
 - iii. First 5 intersections down on hoops, then every second intersection.
 - iv. Every intersection along spine.
 - v. Extra large baskets – every intersection along corner.
 - vi. Every intersection around ends
 - vii. Every intersection along struts (if applicable)
 - c. Bend and trim cells bent in to fit mesh as required and weld in position.
 - d. Grind high spots off body mesh welds on ends before welding end mesh.
 - e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
 - f. Record welding rod PO on attached material list.

9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
 - i. Record welding rod PO on attached material list.
 - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - i. Cut inboard rim on aft end. Grind flush with hoops.
 - ii. TIG weld caps on open tubes.
 - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - i. Record welding rod PO on attached material list.
 - ii. Record placard bracket WO on attached material list.

AD-05

10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

dk

11. Final Inspection

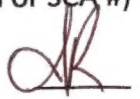
To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
 - i. Hoops for height.
 - ii. Rim for width and length and alignment.
 - iii. Lid prop lugs in correct ends.
 - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

dk

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)



- e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 76423

Aircraft: Eurocopter

Model: AS350

Description: Large Mount Hoop

Supplier: Aero Design

Color: N/A

WO#: 2014-29

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 76423

Aircraft: Eurocopter

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Color: N/A

WO#: 2014-29

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

76421-01

Aircraft:

Eurocopter

Model: AS350

Description:

Short/Medium/Long Hoop

Supplier:

Aero Design

Color:

N/A

WO#:

2014-29

PO# N/A

AS390 LOWE



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

| | | |
|--------------|------------------------|--------------|
| Quantity: | 1 | |
| PN: | 76421-01 | |
| Aircraft: | Eurocopter | Model: AS350 |
| Description: | Short/Medium/Long Hoop | |
| Supplier: | Aero Design | |
| Color: | N/A | |
| WO#: | 2014-29 | PO# N/A |

AS 350 LONG



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 76421-01

Aircraft: Eurocopter

Model: AS350

Description: Short/Medium/Long Hoop

Supplier: Aero Design

Color: N/A

WO#: 2014-29

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

76421-01

Aircraft:

Eurocopter

Model: AS350

Description:

Short/Medium/Long Hoop

Supplier:

Aero Design

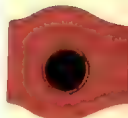
Color:

N/A

WO#:

2014-29

PO# N/A





Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC

V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 76421-01

Aircraft: Eurocopter

Model: AS350

Description: Short/Medium/Long Hoop

Supplier: Aero Design

Color: N/A

WO#: 2014-29

PO# N/A

Work Order: 2014-73Date Opened: 19 SEPT 2014

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Body Fabrication

1 of 2

| Ass'y Step | Qty | Detail Drawing | Part Number | Description | Material | PO/NO |
|------------------|-------|----------------|-----------------|------------------------------------|------------------------------------|--------------|
| | | | 78411-01 | Basket Assembly | | |
| Step 1 | | | | <i>Rim Assembly</i> | | |
| | . 2 | | -- | 3/4" Tube - Long Rim (93.25") | 4130 Steel, 3/4" x 0.035 Sqr. Tube | 14609 |
| | . 2 | | -- | 3/4" Tube - Short Rim (22.5") | 4130 Steel, 3/4" x 0.035 Sqr. Tube | 1223 |
| Step 2 | | | | <i>Weld Rim Assembly</i> | | |
| | . A/R | | -- | Welding Rod | ER70S-2 TIG Rod | PO # 14005 |
| Step 3 | | | | <i>Inspection - Rim</i> | None | |
| Step 4 | | | | <i>Frame Assembly</i> | | |
| | . 4 | | 76421-01 | Hoop - standard | 4130 Steel, 1/2" x 0.035 Sqr. Tube | 2014-29 |
| | . 2 | | 76423-01 | Attachment hoop (aft) | | Watt 2014-29 |
| | . 5 | | -- | 1/2" Tube - spine | 4130 Steel, 1/2" x 0.035 Sqr. Tube | |
| Step 4.g. | | 70406 | 70406-01 | Option: Front End Cutout | | |
| | | | 70406-03 | 1/2" Tube | 4130 Steel, 1/2" x 0.035 Sqr. Tube | |
| | | | 70406-04 | 1/2" Tube | 4130 Steel, 1/2" x 0.035 Sqr. Tube | |
| Step 5 | | | | <i>Weld Frame Assembly</i> | | |
| | . A/R | | -- | Welding Rod | ER70S-2 TIG Rod | PO # 14005 |
| Step 6 | | | | <i>Inspection - Frame Assembly</i> | None | |
| Step 7 | | | | <i>Mesh Assembly</i> | | |
| | . 1 | | -- | Mesh (Body - 48" x 92.25") | 3/4-16F Expanded Mild Steel sheet | 12065 |
| | . 2 | | -- | Mesh (End - 22" x 17") | 3/4-16F Expanded Mild Steel sheet | 12065 |
| Step 8 | | | | <i>Weld Mesh</i> | | |
| | . A/R | | -- | Welding Rod | ER70S-6 MIG Wire | PO # 14028 |

Work Order: 2014-73Date Opened: 19 SEPT 2014Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Body Fabrication

2 of 2

| Ass'y Step | Qty | Detail Drawing | Part Number | Description | Material | PO/WO |
|----------------|-------|----------------|-------------|------------------------------------|-------------------------------|-------------|
| Step 9 | | | | <i>Weld Basket Components</i> | | |
| Step 9.a. | . 2 | | 49215-01 | Spacer (Lid prop) | 304 Stainless Steel, ½" Dia. | WO# 2014-39 |
| | . A/R | | -- | Welding Rod | ER308L TIG Rod | PO# 14028 |
| Step 9.b. | . 2 | | -- | Cap | 1018 Mild Steel, 0.032" Sheet | PO# 9010 |
| | . A/R | | -- | Welding Rod | ER70S-2 TIG Rod | PO# 14005 |
| Step 10 | | | | <i>Clean Up</i> | <i>None</i> | |
| Step 11 | | | | <i>Inspection - Final Assembly</i> | <i>None</i> | |
| Step 12 | | | | <i>Powder Coating</i> | | |

CARGO BASKET LID FABRICATION - COMMON

2014-73

General

AS350 Long x1

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

→ 78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

Bell 429 – right or left

95912, Revision 0 – Standard Basket

Bell Medium – left or right

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

MD600

82812, Revision 0 – Standard Basket

Options

→ 70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2014-73

Date Open: 19 SEPT 2014

1. Rim Assembly – Basket Lid

AD06

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.

2. Weld Rim Assembly

AD-05

- a. Record welding rod PO on attached material list.

3. Inspection

AD06

- a. Rim for complete welds

4. Frame assembly – Lid

AD06

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- b. Insert rim from step 2 into jig.
- c. Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- d. Record material PO on attached material list.
- e. Remove writing on tubes with acetone and scotch bright.
- f. Drill vent holes into rim to vent cross members into rim.
- g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

5. Frame assembly – Lid with optional walkway modification

AD06

- a. Fit cross members to rim in accordance with step 4.
- b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- c. Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- d. Drill vent holes into cross members at walkway stringers.
- e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

6. Weld frame assembly.

AD-05

- a. Record welding rod PO on attached material list.
- b. Jigs must remain in place for as long as practical during welding.

7. Inspection

AD06

- a. Frame assembly for complete welds.

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

ADG

8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid.
- Remove surface rust with scotch-brite.
- Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing.

AD-05

- General welding requirements for all lids:
 - Every intersection on all edges.
 - First 5 intersections along cross members, then every second intersection.
- MIG weld both short sides.
- Clamp lid over spacer at centre of lid to pre-tension mesh.
 - $\frac{3}{4}$ " for lids under 76"
 - 1" (check) for lids over 76"
- Weld remainder of mesh as indicated in a.
- Record welding rod PO on attached material list.

10. Weld lid components.

AD-05

- Handle brackets, locate in accordance with drawing.
 - Standard location: $\frac{1}{4}$ " outside of last cross member on both ends.
 - Record handle bracket WO and welding rod PO on attached material list.
- Lid prop bushing(s).
 - one or two in accordance with drawing.
 - Record lip prop bushing WO and welding rod PO on attached material list.
- Placard bracket. – not installed on 95912 (Bell 429)
 - Locate on cross member to set bracket in centre bay of lid.
 - Record placard bracket WO and welding rod PO on attached material list.

11. Clean up

ADG

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Drill #9 through lid prop bushing(s). De-burr hole(s).
- Drill for lid bumpers using $\frac{1}{4}$ " (#3) centre drill.
 - 3 places for lids under 76"
 - 4 places for lids over 76"
- Remove surface rust with scotch-brite pad.

12. Final Inspection

To be completed by a different person than the previous steps.

ADG

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)



13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

Work Order: 2014-73Date Opened: 19 SEPT 2014Material Tracking Sheet
Eurocopter AS350 / AS355
Long Lid Fabrication

1 of 2

| Ass'y Step | Qty | Detail Drawing | Part Number | Description | Material | PO/WO |
|---------------|-------|----------------|-----------------|--|------------------------------------|-----------|
| | | | 78412-01 | Lid Assembly | | |
| Step 1 | | | | <i>Rim Assembly</i> | | |
| | . 2 | | -- | 3/4" Tube - Long Rim (93.25") | 4130 Steel, 3/4" x 0.035 Sqr. Tube | 14009 |
| | . 2 | | -- | 3/4" Tube - Short Rim (22.5") | 4130 Steel, 3/4" x 0.035 Sqr. Tube | 12123 |
| Step 2 | | | | <i>Weld Rim Assembly</i> | | |
| | . A/R | | -- | Welding Rod | ER70S-2 TIG Rod | PO# 14005 |
| Step 3 | | | | <i>Inspection - Rim</i> | None | |
| Step 4 | | | | <i>Frame Assembly</i> | | |
| | . 4 | | -- | 3/4" Tube - Cross Member (21") | 4130 Steel, 3/4" x 0.035 Sqr. Tube | 14009 |
| Step 5 | | 70405 | | <i>Option: Frame Assembly - with walkway</i> | | |
| | . 8 | | -- | 1/2" Tube - walkway | 4130 Steel, 1/2" x 0.035 Sqr. Tube | 14009 |
| Step 6 | | | | <i>Weld Frame Assembly</i> | | |
| | . A/R | | -- | Welding Rod | ER70S-2 TIG Rod | PO# 14005 |
| Step 7 | | | | <i>Inspection - Frame Assembly</i> | None | |
| Step 8 | | | | <i>Mesh Assembly</i> | | |
| | . 1 | | -- | Mesh (lid - 92.5" x 22") | 3/4-16F Expanded Mild Steel sheet | 12065 |
| Step 9 | | | | <i>Weld Mesh</i> | | |
| | . A/R | | -- | Welding Rod | ER70S-6 MIG Wire | PO# 14028 |

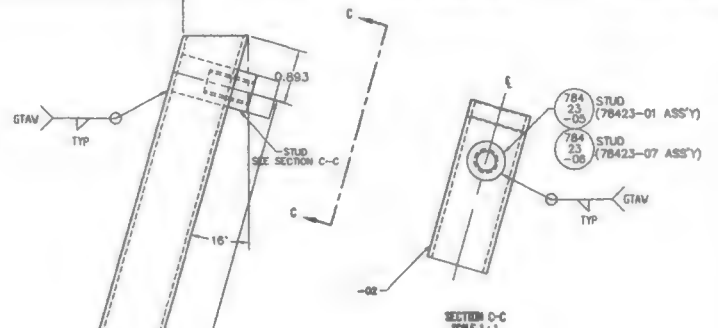
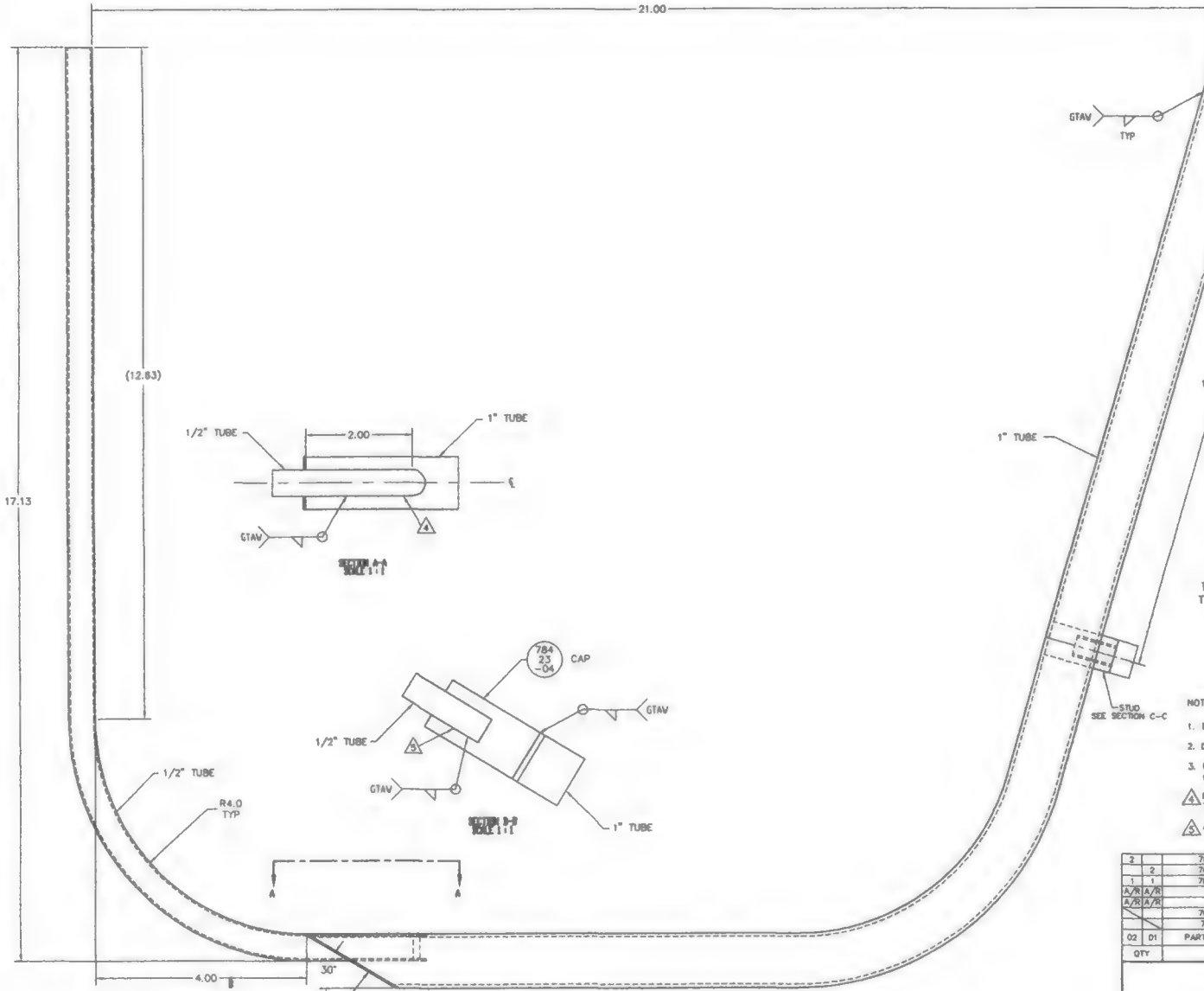
Work Order: 2014-73Date Opened: 19 SEPT 2014Material Tracking Sheet
Eurocopter AS350 / AS355
Long Lid Fabrication

2 of 2

| Ass'y Step | Qty | Detail Drawing | Part Number | Description | Material | PO/WO |
|----------------|-------|----------------|-------------|------------------------------------|----------------------------|-------------|
| Step 10 | | | | <i>Weld Lid Components</i> | | |
| | . 1 | 84262 | 84262-01 | Upper Handle Bracket Assembly | | WO# 2014-38 |
| | . . 4 | | 36273-01 | Lid Bracket | 321 Stainless, 0.050 Sheet | |
| | . . 2 | | 36275-02 | Support | 304 Stainless, 5/16" Rod | |
| | . A/R | | -- | Welding Rod | ER308L TIG Rod | PO# 14028 |
| | . 2 | | 49216-01 | Spacer (Lid prop) | 304 Stainless, 1/2" Dia. | WO# 2014-09 |
| | . A/R | | -- | Welding Rod | ER308L TIG Rod | PO# 14028 |
| | . 1 | | 36204-10 | Placard Bracket | 1018 Steel, 0.035" Sheet | WO# 2014-18 |
| | . A/R | | -- | Welding Rod | ER70S-2 TIG Rod | PO# 14005 |
| Step 11 | | | | <i>Clean Up</i> | | |
| Step 12 | | | | <i>Inspection - Final Assembly</i> | | |
| Step 13 | | | | <i>Powder Coating</i> | | |

2014-73

| REVISIONS | | | |
|-----------|---------------------------------------|----------|------------|
| REV | DESCRIPTION OF CHANGE | INITIALS | DATE |
| 0 | INITIAL ISSUE | RR | 24 JAN 08 |
| 1 | ADDED 78423-07 ASSY AND 78423-08 PART | RR | 05 MAR 09 |
| 1 | CHANGED LENGTH OF STUD (ITEM 05) | QJC | 18 JUNE 10 |



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. DRILL 3/32 VENT HOLE IN HOOP FOR VENTING OF WELD GASES.
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS2885C. WELDING ROD SHALL CONFORM TO AWS ER70S-2 OR EQUIVALENT.
4. MILL SLOT INTO ITEM 1" TUBE AS SHOWN. CONTOR END OF 1/2" TUBE TO MINIMIZE GAP BETWEEN 1" TUBE AND ITEM 1/2" TUBE.
5. ADJUST SLOT OF CAP (78423-04) TO FIT AS REQUIRED.

| QTY | PART NO | ITEM | DESCRIPTION | MATERIAL | MATERIAL SPEC | STOCK SIZE |
|---------|----------|------|--------------------------|-------------------|-------------------|----------------------|
| 2 | 78423-06 | 06 | STUD | MILD STEEL | AISI 1010/1020 | 1/2 X 1 1/2 |
| 2 | 78423-05 | 05 | STUD | MILD STEEL | AISI 1010/1020 | 1/2 X 1 1/2 |
| 1 | 78423-04 | 04 | CAP | MILD STEEL SHEET | 4130 STEEL COND N | 5-500 3/4 X 1 1/2 |
| A/A/A/R | 03 | 03 | TUBE 1/2IN | 4130 STEEL COND N | MIL-T-8736 | 0.5 X 0.035 SDR TUBE |
| A/A/A/R | 02 | 02 | TUBE 1IN | 4130 STEEL COND N | MIL-T-8736 | 1 X 0.065 SDR TUBE |
| | 78423-07 | 07 | ATTACHMENT HOOP ASSEMBLY | (USED ON 78411) | | |
| | 78423-01 | 01 | ATTACHMENT HOOP ASSEMBLY | | | |

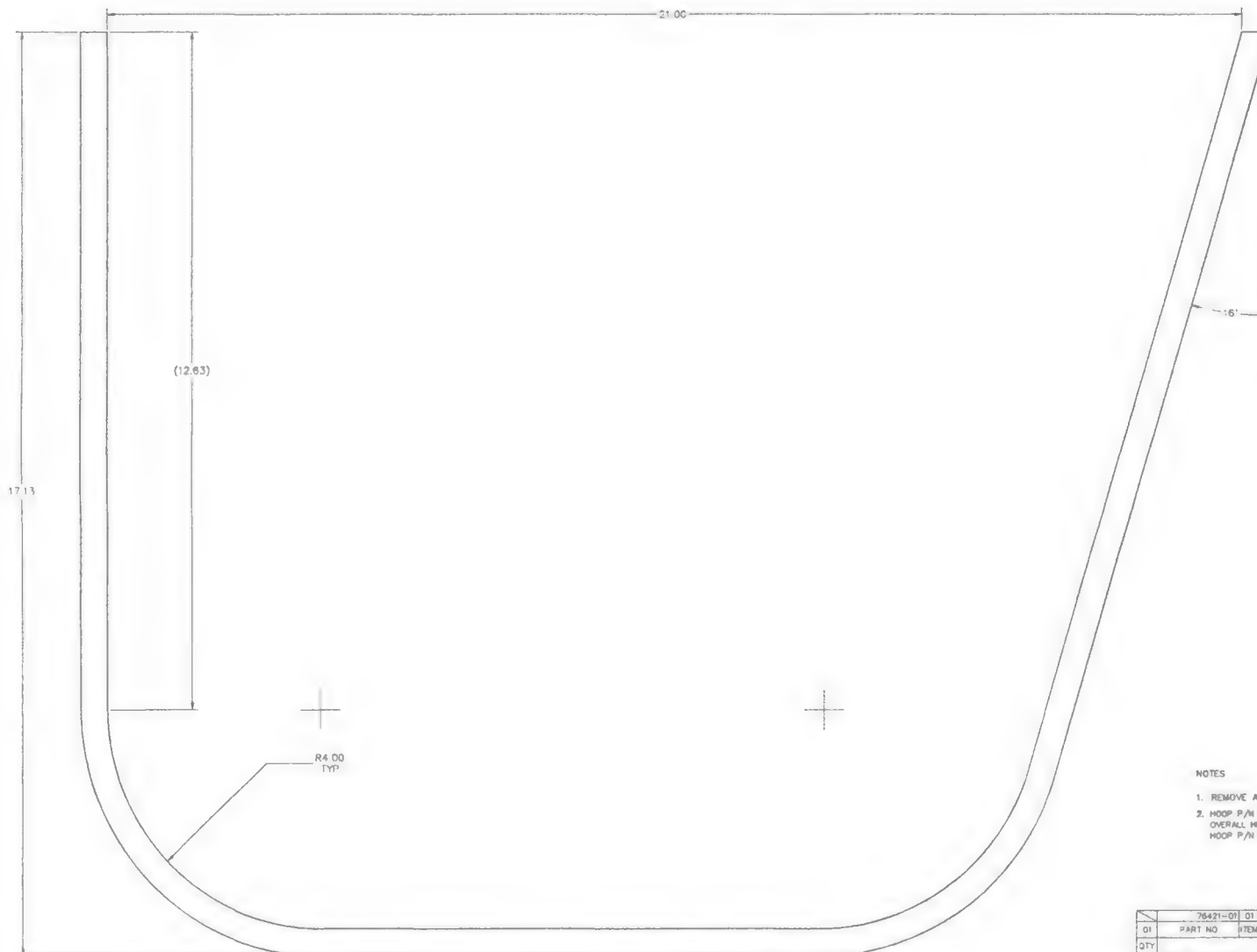
APPROVALS DATE
 DRAWN R. RATHWELL 24 JAN 08
 CHECKED E. BURGOIN
 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:
 DECIMALS ±0.010
 FRACTIONS ±0.03
 ANGLES ±1/2°

AS350 & AS355 SERIES
 QUICK RELEASE CARGO BASKET
 ATTACHMENT HOOP ASSEMBLY
 SCALE 1 : 1
 SHEET 1 OF 1
 A1 76423 2

78423-01 ATTACHMENT HOOP ASSEMBLY
 SCALE 1 : 1

78423-07 ATTACHMENT HOOP ASSEMBLY (USED ON 78411)
 ALL FEATURES SIMILAR TO 78423-01 EXCEPT STUDS. SEE SECTION C-C
 SCALE 1 : 1

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|---|-----------------------|----------|-----------|
| REV | DESCRIPTION OF CHANGE | INITIALS | DATE |
| 0 | INITIAL ISSUE | RR | 24 JAN 08 |



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. HOOP P/N 50510-01 IS USED AS A DIRECT REPLACEMENT FOR HOOP P/N 76421-01. OVERALL HEIGHT IS REDUCED BY 1.38 IN. THERE ARE NO OTHER CHANGES.

HOOP P/N 50510-01 IS USED ON BASKET S/N 76401-01, 76401-02, 76401-01, 77801-01, 77802-01 ONLY

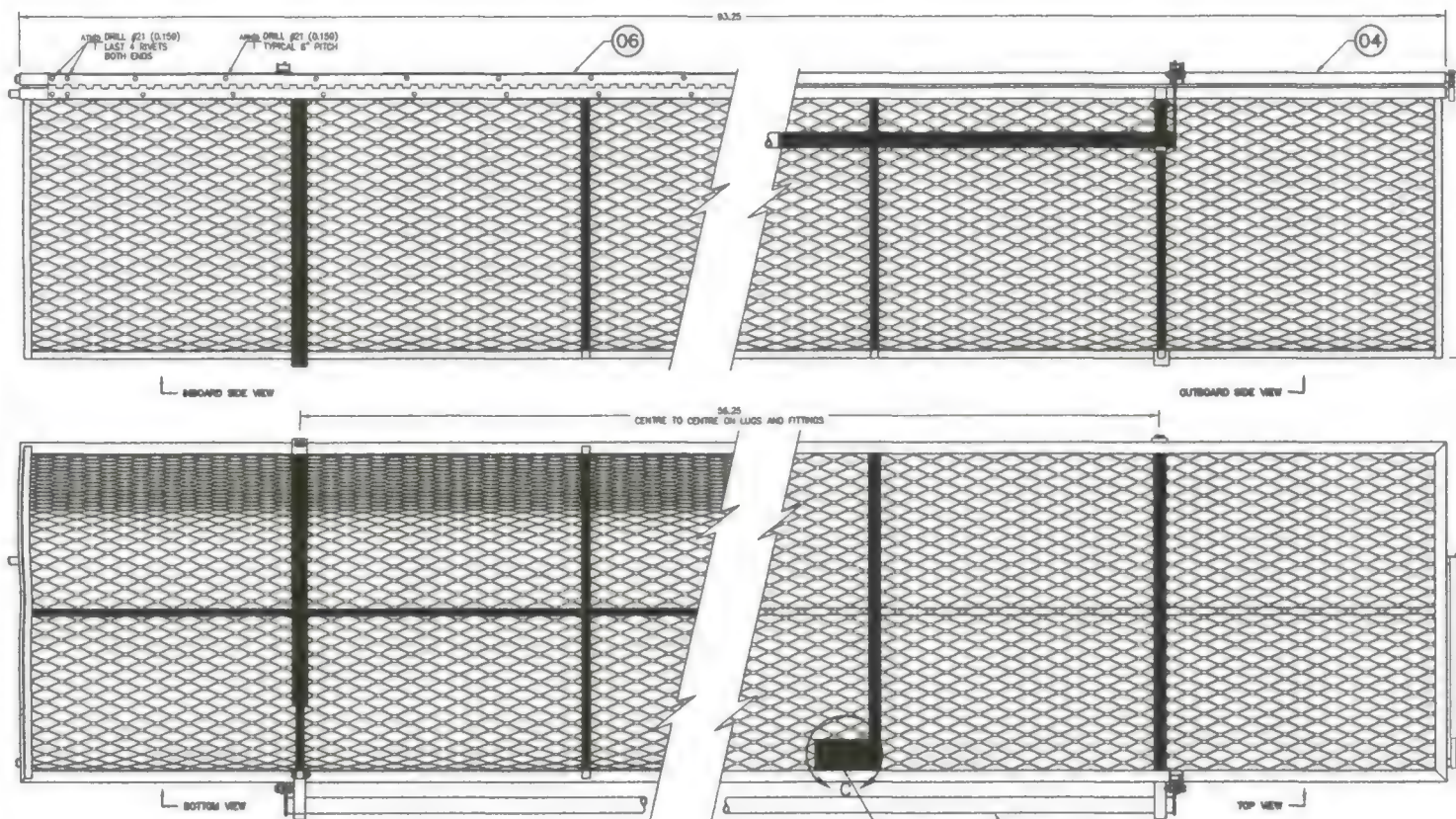
01 HOOP
SCALE 1 : 1

| | | | | | | | | |
|---|---------|------|---|----------|---------------|------------|----------------------|-----|
| 76421-01 01 HOOP | | | 4130 STEEL COND N | | MIL-T-8136 | | 0.5 X 0.035 SQR TUBE | |
| Q1 | PART NO | ITEM | DESCRIPTION | MATERIAL | MATERIAL SPEC | STOCK SIZE | | |
| LIST OF MATERIALS | | | | | | | | |
| APPROVALS | | | DATE | | | | | |
| DRAWN | | | R. RATHWELL 24 JAN 08 | | | | | |
| CHECKED | | | E. BURCON | | | | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: | | | CONSULTING ENGINEERS TRANSPORT CANADA APPROVALS, DAR 2904 2013 - 3081 AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 8R7 tel: (403) 800-0887 fax: (403) 800-8283 www.aero-design.ca | | | | | |
| DIMENALS | | | ANGLES | | | | | |
| X.XXX ±0.010 | | | ±1/2" | | | | | |
| X.XX ±0.03 | | | | | | | | |
| X.X ±0.1 | | | | | | | | |
| SCALE 1 : 1 | | | | DWG SIZE | | DWG NO | | REV |
| SHEET 1 OF 1 | | | | A1 | | 76421 | | 0 |

AERO DESIGN LTD.
CONSULTING ENGINEERS TRANSPORT CANADA APPROVALS, DAR 290M
2013 - 38TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 8B7
tel: (403) 850-8887 fax: (403) 850-8333 www.aerodesign.ca

**EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
HOOP**

| REV | DESCRIPTION OF CHANGE | INITIALS | DATE |
|-----|---|----------|-----------|
| 0 | INITIAL ISSUE | | |
| 1 | CHANGES TO BASKET CONFIGURATION, REMOVED ALTERNATE BASKET | BUC | 27 JAN 10 |

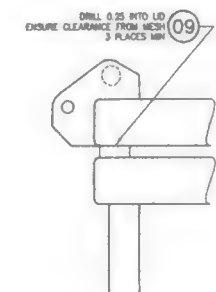


01 CARGO BASKET ASSEMBLY

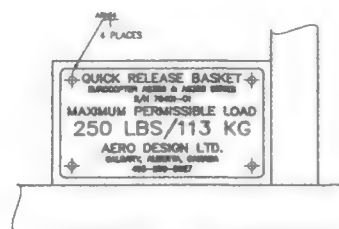
NOTE:
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

| A/R | QTY | PART NO. | DESCRIPTION | MATERIAL | MATERIAL SPEC | STOCK SIZE |
|-----|-----|-------------|-------------------------------|----------|---------------|------------|
| A/R | 4 | 4008B-14 | WASHER | | | |
| B | 1 | CR3523-5-02 | CHERRY RIVET | ANCHOR | | |
| A/R | 4 | CR3213-5-02 | CHERRY RIVET | | | |
| A/R | 4 | CR3213-4-02 | CHERRY RIVET | | | |
| 3 | 1 | 78427-01 | PLACARD | | | |
| 1 | 1 | 84255-01 | HANDLE BAR INSTALLATION | | | |
| A/R | 1 | MS20001P4 | PLATING | | | |
| 1 | 1 | 36280-01 | BRACE ASSEMBLY | | | |
| 1 | 1 | 78412-01 | LID ASSEMBLY | | | |
| 1 | 1 | 78411-01 | BASKET BODY ASSEMBLY | | | |
| 02 | | | | | | |
| 01 | 1 | 78410-01 | QUICK RELEASE BASKET ASSEMBLY | | | |
| QTY | | PART NO. | DESCRIPTION | MATERIAL | MATERIAL SPEC | STOCK SIZE |

LIST OF MATERIALS



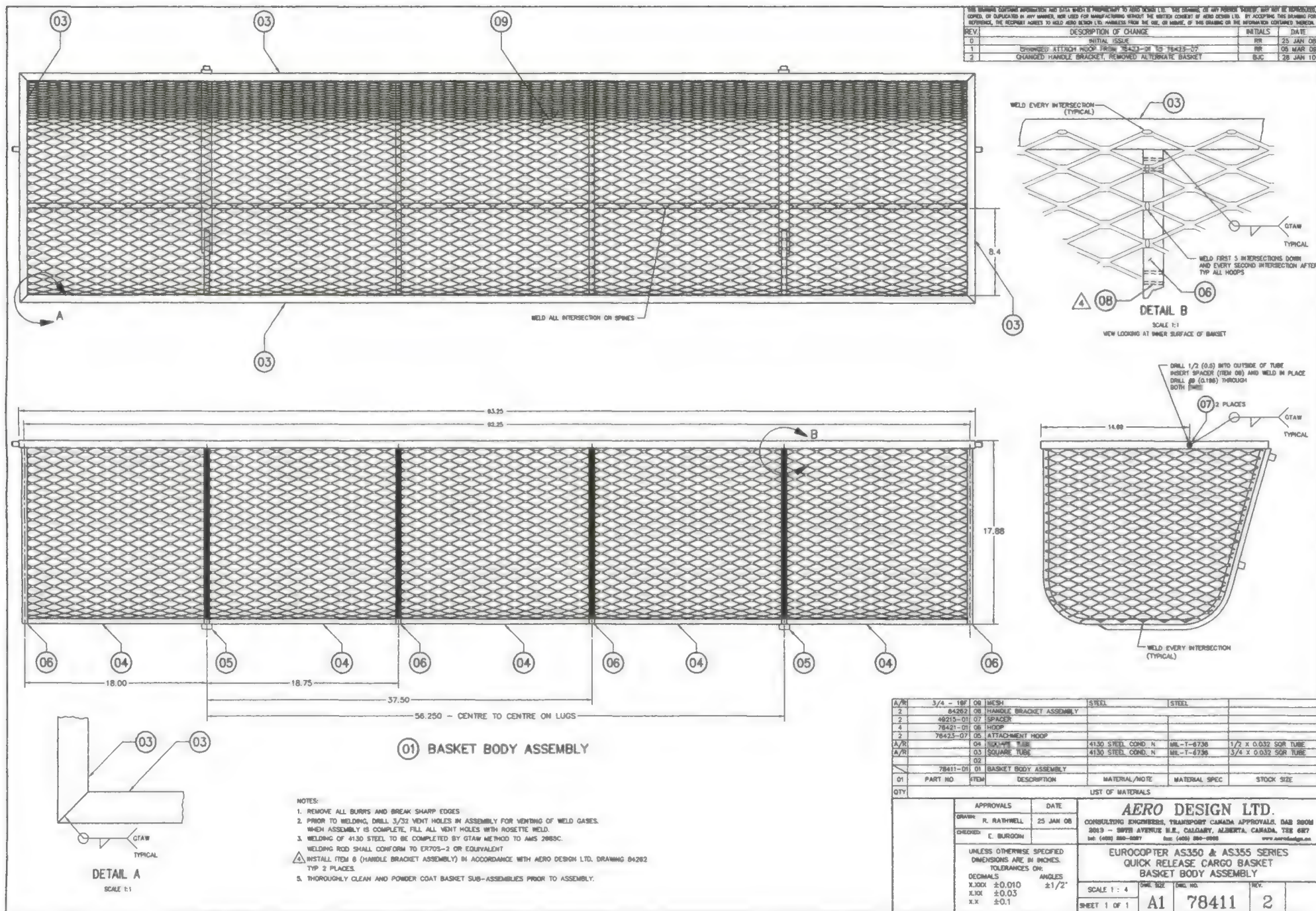
SCALE 1:1



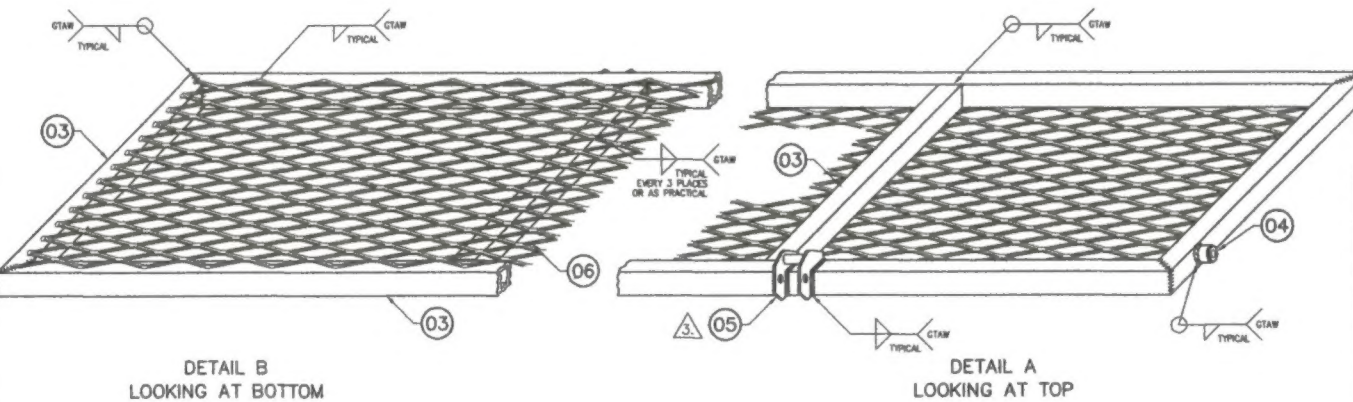
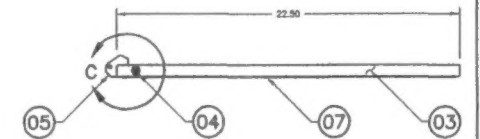
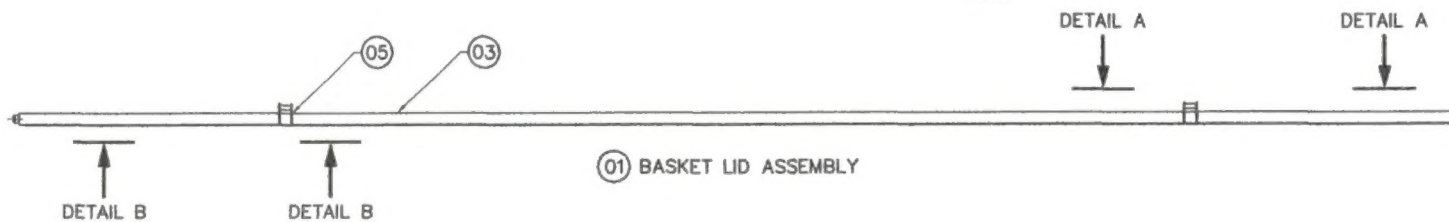
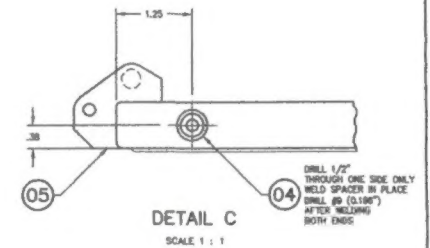
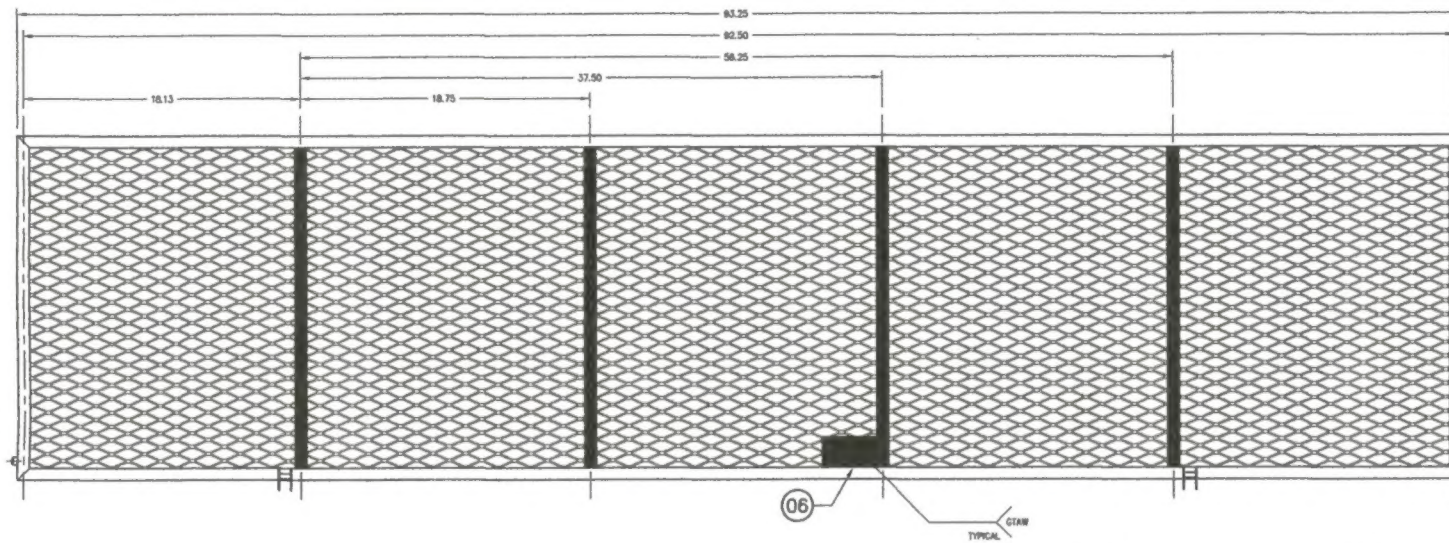
DETAIL C

SCALE 1:1
LOOKING AT PLACARD BRACKET

| | | | |
|---|--|--|---------------------------|
| BASIC CODE REF. WAS 003 | DASH NO. FOR DIAMETER H=MTD. HEAD NEAR SIDE T=MTD. HEAD FAR SIDE | APPROVALS DRAWN: R. RATHNELL CHECKED: E. BURGOON | DATE 19 FEB 08 |
| C=COMPLETION D=COMPLETE D=0 OF SHEETS TO BE COMPLETED | DASH NO. FOR LENGTH H=MTD. HEAD NEAR SIDE T=MTD. HEAD FAR SIDE | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE: DECIMALS X.XXX ±0.010 X.XX ±0.03 X.X ±0.1 | ANGLES ±1/2° |
| BASIC CODES: BU=MS20470AD BB=MS20428AD AH=CR3213 ATW=CR3523 | INSTALL NEW RIVET REMOVE/REPLACE RIVET EXISTING RIVET | EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE SKI BASKET BASKET ASSEMBLY | SCALE 1:4 SHEET 1 OF 1 |
| | | REV. NO. A1 | REV. NO. 1 |



| REVISIONS | | | INITIALS | DATE |
|-----------|---|----------|-----------|------|
| REV | DESCRIPTION OF CHANGE | INITIALS | DATE | |
| 0 | INITIAL ISSUE | | | |
| 1 | CHANGED HANDLE BRACKETS, REMOVE ALTERNATE LID | BUC | 28 JAN 10 | |



- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS D885C. WELDING ROD SHALL CONFORM TO EKTOS-2 OR EQUIVALENT.
 3. INSTALL ITEM 5 (HANDLE BRACKET ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 35262. TYP 2 PLACES.
 4. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

| | | | | | |
|---|---------------------------------------|-------------------|-------------|----------------------|---------------|
| A/R | 3/4-18F 07 MESH | | | | |
| 1 | 35204-10 08 PLACARD BRACKET | | | | |
| 1 | 84262-01 05 UPPER HANDLE BRACKET ASSY | | | | |
| 2 | 48216-01 04 SPACER | | | | |
| A/R | 03 SQUARE TUBE | 4130 STEEL COND N | MIL-T-8738 | 3/4 X 0.035 SQR TUBE | |
| | 02 | | | | |
| | 78412-01 01 BASKET LID ASSEMBLY | | | | |
| QTY | PART NO. | ITEM | DESCRIPTION | MATERIAL | MATERIAL SPEC |
| | | | | | STOCK SIZE |
| LIST OF MATERIALS | | | | | |
| APPROVALS | | | DATE | | |
| DRAWN: R. RATHWELL | | | 19 FEB 08 | | |
| CHECKED: E. BURGOON | | | | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: | | | | | |
| DECIMALS | | | ANGLES | | |
| X.XXX ±0.010 | | | ±1/2" | | |
| X.XX ±0.03 | | | | | |
| X.X ±0.1 | | | | | |
| SCALE 1 : 4 | | | DWG NO. | | |
| SHEET 1 OF 1 | | | REV. | | |
| A1 | | | 78412 | | |
| | | | 1 | | |

| REV. | DESCRIPTION OF CHANGE | INITIALS | DATE |
|------|-----------------------------------|----------|-----------|
| 0 | INITIAL ISSUE | | |
| 1 | INCREASE LOAD TO 250 LBS / 113 KG | BJC | JAN 27/10 |

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.125 HIGH
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH
"S/N 78401-XX" - 0.080 HIGH
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
"250 LBS/113 KG" - 0.200 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"CALGARY, ALBERTA, CANADA" - 0.080 HIGH
"403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)
4 PLACES



01 PLACARD

| 78427-01 | 01 | PLACARD | 6061-T6 ALUMINUM | QQ-A-250/11 | 0.063 SHEET |
|----------|------|-------------|------------------|---------------|-------------|
| PART NO. | ITEM | DESCRIPTION | MATERIAL | MATERIAL SPEC | STOCK SIZE |

LIST OF MATERIALS

| | | | | | | | | |
|---|--|--|-----------|--------------|---|-----------------|-------------------|-----------|
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| | DRAWN: R. RATHWELL | | 18 FEB 08 | | CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca | | | |
| | CHECKED: E. BURGAIN | | | | EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET PLACARD | | | |
| | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1 | | | | SCALE 1 : 1 | DWG. SIZE A1 | DWG. NO. 78427 | REV. 1 |
| | | | | SHEET 1 OF 1 | | | | |

[illegible]

| | | | | | | |
|---|--------------------------|---|----------|--|--|-----------------------------------|
| 1. Approving Civil Aviation Authority/Country Transport Canada | | 2. AUTHORIZED RELEASE CERTIFICATE FORM ONE | | | 3. Form Tracking No. | |
| 4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3 | | | | | 5. Work Order/Contract/Invoice WO2014-73 | |
| 6. Item | 7. Description | 8. Part Number | 9. Qty. | 10. Serial/Batch No. | 11. Status/Work | |
| | Long Cargo Basket | 78410-01 | 1 | 78401-53 | New | |
| 12. Remarks Modified with walkway on lid IAW DCL704; Black | | | | | | |
| 13a. Certifies that the items identified above were manufactured in conformity to: | | | | 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 | | |
| <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12. | | | | Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. | | |
| 13b. Signature <i>Jeff Clarke AD02</i> | | 13c. Approved Organization Number AMF 73-04 | | 14b. Signature | | 14c. Approved Organization Number |
| 13d. Name Jeff Clarke - AD02 | | 13e. Date (dd/mmm/yyyy) 27 Oct 2014 | | 14d. Name | | 14e. Date (dd/mmm/yyyy) |
| <p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p> | | | | | | |

SILVER KING